AVOX Systems **QUALITY ASSURANCE**	**SUPPLIER QUALITY ASSURANCE REQUIREMENTS** QUALITY REQUIREMENTS SPECIFIED IN THIS DOCUMENT ARE PART OF THE TERMS AND CONDITIONS OF THE PURCHASE ORDER FOR WHICH THEY ARE REFERENCED. FAILURE TO COMPLY MAY RESULT IN WITHHOLDING ACCEPTANCE OF SHIPMENT OR DELAY IN PAYMENT OF INVOICE.

The purpose of this document is to establish the AVOX Systems Supplier Quality Assurance requirement codes necessary to ensure that materials and services meet requirements.

The quality requirements specified in this document are part of the Terms and Conditions of the applicable purchase order.

GENERAL REQUIREMENTS: the requirements in this section apply to all purchase orders

100 CONTROL OF QUALITY
The supplier is required to provide and maintain an Inspection and Quality Control System commensurate with the complexity and reliability of the product to be supplied, and with the quality requirements of the Purchase Order. The system employed shall be subject to verification by AVOX Systems Inc.

102 INSPECTION SYSTEM REQUIREMENTS
Replaced and must comply with Clause 100.

107 RECORD RETENTION
The supplier shall maintain on file at the supplier's facility, quality records traceable to the conformance of product delivered to AVOX Systems. The supplier shall make such records available to regulatory authorities and AVOX Systems representatives. The supplier shall retain such records for a period of not less than 10 years from the date of shipment. At the expiration of the 10 years contact AVOX Systems for disposition.

109 SUB-TIER SUPPLIER FLOW DOWN
The supplier is required to flow down all applicable AVOX Systems purchase order requirements to sub-tier suppliers including design data and any special instructions.

200 FIRST-ARTICLE INSPECTION (FAI)
The Supplier shall submit a First Article Inspection (FAI) when any of the following occur:

- The first time material is provided (full FAI)
- A change in design (partial FAI for affected features/characteristics)
- A change in manufacturing source(s), process(es), inspection method(s), location of manufacture, tooling, materials, NC programming, natural or man made event (force majeure) (full FAI).
- The first time material is provided in over 2 years (full FAI)

First Article material shall be produced using production tooling, processing and methods and must include all design data specified by the PO, Engineering drawing and any other applicable design document. A material certificate and special process certificate where applicable must be provided with the FAI report.
A copy of the FAI report must be provided with the material it represents. All characteristics must be compliant with the design data unless previous approval has been given by AVOX Systems.

OR :

Must comply with SAE AS9102 or equivalent. A copy of the FAI report must be provided with the material it represents.
All characteristics must be compliant with the design data unless previous approval has been given by AVOX Systems.

302 CERTIFICATION OF CONFORMANCE
Each shipment shall be accompanied by a signed and dated certification which will include the AVOX Systems Inc. Purchase Order number, AVOX Systems Inc. part number and current revision, serial number(s), lot/batch or heat number(s), the quantity from each lot, supplier's P/N and shelf life/expiration date as applicable indicating the material or product meets requirements of all applicable drawing, specifications, standards and Purchase Order.

306 BANNED SUBSTANCES
The use of any BANNED SUBSTANCES as shown below shall not be used in the manufacture of AVOX products. If any of these substances are used contact AVOX Systems buyer. BANNED SUBSTANCES : Brominated Flame Retardants (Pentabromodipheny Ether, and Octabromodiphenyl Ether) \ Beryllium and its compounds \ Cadmium \ Hexavalent chromium \ Halon \ Freons \ Lead and its compounds \ Radioactive material \ Asbestos and like fibers \ Mercury \ PCBs

402 GOVERNMENT/ AVOX SYSTEMS INC. / CUSTOMER REVIEW OF PERFORMANCE
During performance of this order, your Quality Control or Inspection System and Manufacturing processes are subject to review, verification and analysis by authorized Government/Customer/AVOX Systems Inc. Inspection or release of product prior to shipment is not required unless you are otherwise notified. You shall provide a copy of this order to the applicable agency representative upon his request

403 AVOX SYSTEMS INC. SOURCE SURVEILLANCE INSPECTION
Replaced and must comply with Terms & Conditions Right of Entry Clause.

500 SUPPLIER CONTROLLED PRODUCTS/PROCESSES
Notify AVOX Systems Inc. Purchasing prior to incorporating any change or substitutions for product ordered. Changes to tools, fixtures, molds, dies or other process controls, which may affect fit, form, or function must have written AVOX Systems Inc. approval.

600 SAMPLING INSPECTION
Sampling Inspection may be employed with a statistically valid sampling plan that precludes the acceptance of lots whose samples have known nonconformities. The use of other sampling plans or schemes is prohibited unless approved by AVOX Systems Inc.

701 WORKMANSHIP QUALITY
Finishes of threads, ports, orifices and intersecting holes shall be free of chips, tumbling media, and loose or hanging burrs and be protected for shipment. Areas having a designated surface finish shall be free of irregularities beyond specified acceptance limits. Levels of optical magnification and illumination to be used shall be appropriate for the inspection. Surfaces shall have uniform finish free of major nicks, gouges, scratches, dents, voids, tool marks or other imperfections.

702 SURFACE TEXTURE
Surface roughness, waviness, and lay characteristics shall conform to American Standards ANSI/ASME B46.1 (unless otherwise specified on drawing) and must be free of flaws and surface irregularities.

801 SOURCE/SPECIFICATION CONTROL
Where Source Control and/or Specification control is a requirement, substitutions, alternatives or equivalents are not to be made for material, product, processes or sources of same without prior written approval of AVOX Systems Inc. Identification of the source of manufacture/process must be provided.

802 NON-CONFORMING PRODUCTS
Non-conforming materials and products are to be identified and segregated for review and disposition. Notify AVOX Systems Inc. Purchasing of such variances at earliest time possible for AVOX Systems Inc. Material Review Board (MRB) action. Shipment of product which fails to conform to AVOX Systems Inc. drawings and specifications is prohibited without written MRB authorization from AVOX Systems Inc.

900 AVOX SYSTEMS INC. GOVERNMENT/CUSTOMER OWNED TOOLING & FIXTURING
Where AVOX, AVOX customer or Government owned Tooling and fixturing are used during the performance of this Purchase Order the tooling and fixturing shall be maintained and stored in such a manner as to prevent damage and deterioration. Annual tool inspection is to be performed with records of results maintained by the Supplier. Notify AVOX Systems Inc. Purchasing should tooling require repair, rework or replacement

901 AVOX SYSTEMS INC. LOANED INSPECTION EQUIPMENT
When standard gauging or other equipment is provided by AVOX for use by the supplier during the performance of this Purchase Order, the equipment is to be maintained and used in a manner to prevent damage and deterioration. A calibration frequency is provided for equipment supplied. In the event this equipment remains at the supplier's facility beyond its scheduled calibration date, the Supplier is responsible to provide for such calibration by an AVOX Systems Inc. approved source or return the equipment to AVOX Systems Inc. for calibration. Exceptions to be approved by AVOX Systems Inc. Quality Assurance. The supplier is responsible for any repairs/replacement of loaned inspection equipment that is lost or damaged while in their possession.

902 CONTAMINATION CONTROL
Components and/or assemblies being supplied have LIFE-SUPPORT BREATHING APPLICATION. Product shall be cleaned to eliminate all contamination such as: tarnish, rust, corrosion, paints, preservative and organic materials such as grease, oil, ink and dye. The use of organic based corrosion/tarnish inhibitors or sealers is prohibited. Hanging burrs, scale, imbedded or attached particulate and loose materials such as chips and flakes must be removed. Packaging used shall maintain cleanliness during shipment and storage.

903 CHEMICALS
All chemical shipments shall comply with appropriate EPA, RCRA, OSHA, and DOT requirements for safe transportation, labeling (smallest unit containers and outer packaging), special or unusual handling requirements, and spill handling instructions. A copy of the MSDS shall be provided with each shipment.

1200 PACKAGING
Packaging codes are specified on the Purchase order after the QA requirement codes (e.g. VS/A). All parts and/or assemblies shall be packaged in accordance with all applicable drawings, specifications and special packaging instructions. If specific packaging instructions are not imposed, the best commercial packaging practices must be used to prevent damage.
Packaging codes are specified on the Purchase Order after the QA requirement codes (e.g. VS/A ; note : "VS" is for AVOX internal use only)
Code A – If Code A is specified on the PO, parts must be individually packaged.
Code B – If Code B is specified, the items have shelf life limitations. Refer to Quality Clause 303 for requirements.
Code C – If Code C is specified, the items may be packaged in bulk.

VARIABLE REQUIREMENTS: these additional requirements apply only when called out on the purchase order by specific code number

101 QUALITY PROGRAM REQUIRMENTS
Replaced and must comply with Clause 104.

103 CALIBRATION SYSTEM REQUIREMENTS
The supplier shall maintain a calibration system compliant with the requirements of ANSI/NCSL Z540-1.

104 QUALITY MANAGEMENT SYSTEM
The Supplier shall maintain a Quality Management System compliant with the applicable requirements of ISO 9001.

105 QUALITY MANAGEMENT SYSTEM
The Supplier shall maintain a Quality Management System compliant with the applicable requirements of AS9100.

300 SPECIAL PROCESS CERTIFICATION
Each shipment shall be accompanied by a signed certification indicating the special process that was performed and the specifications/standards that it was performed and compliant to. Inspection and test reports are to be maintained on file and available for review. Special processes include but are not limited to heat treating, welding, brazing, plating, and non-destructive testing processes such as x-ray, penetrant, magnetic particle, ultrasonic, and visual inspection.

301 CHEMICAL/PHYSICAL TEST REPORTS
Each shipment shall be accompanied by a copy of the original test report containing quantitative data for the chemical analysis or physical properties, as applicable, for the material supplied or used in the manufacture of the product.

303 SHELF LIFE CERTIFICATION
Products shall have no more than 25% of the usable shelf life (ref SIO 14) expired when delivered. Each shipment shall be accompanied by a signed and dated certification listing cure and/or manufacture date. Cure and /or manufacturing date shall also be physically marked on product or packaging. Note : for cylinders reference SIO66.

304 FUNCTIONAL TEST REPORT
Each shipment shall be accompanied by a copy of the actual Functional Test Report, which reflects the quantitative data on which product acceptance was based. Product shall be 100% inspected or tested to ensure conformance. Reports shall be identified to the product by serial number or other traceable means.

305 MERCURY EXCLUSION CLAUSE
Mercury Contamination – (i.e., during the manufacturing process, test or inspections). Supplies offered shall not come in direct contact with mercury or any of its compounds nor with any mercury containing devices employing a single boundary of containment (A single boundary of containment is one which is not backed by a second seal or barrier to prevent contamination in event of rupture of the primary seal or barrier). Mercury contamination of the supplies will be cause for rejection of the supplies.

307 OXYGEN COMPATIBLE ELASTOMERS & LUBRICANTS
Products offered containing elastomers and/or lubricants must be considered compatible with oxygen. A listing of all elastomeric compounds and/or lubricants contained in the products offered is to accompany each shipment of product.

400 AVOX SYSTEMS INC. SOURCE INSPECTION
The supplier shall notify AVOX Systems Inc. Procurement at least (72) hours prior to the start of final inspection and/or acceptance test to facilitate witnessing by an AVOX Systems Inc. representative(s). The supplier shall not proceed without AVOX Systems authorization.

401 GOVERNMENT SOURCE INSPECTION
Government Source Inspection is required prior to shipment. Upon receipt of this order, promptly notify the Government Representative who normally services your facility so that appropriate planning for inspection can be accomplished.

404 FAA SOURCE SURVEILLANCE
Suppliers of articles/services defined in this purchase order are subject to surveillance and/or evaluation by the Federal Aviation Administration. An 8130-3 tag is required when direct shipment authorization has been granted by AVOX Systems.

700 SPECIAL INSTRUCTIONS
Special instructions apply. These instructions are provided by a separate document and are not specifically detailed by AVOX Systems Inc. drawings, specifications or standards. The supplier is required to follow such instructions during the manufacture and inspection of the product.

703 CRITICAL CHARACTERISTICS
100% inspection is mandatory for all critical characteristics classified as critical on the PO/contract. Inspection reports must be provided with shipment.

704 KEY CHARACTERISTICS
Statistical methods such as SPC or other statistical techniques must be used to monitor characteristics classified as key.

800 TEST SPECIMENS
Specimens of materials or products shall be furnished to AVOX Systems Inc. for verification testing. Specimens shall be of the type, configuration, and quantity required by AVOX Systems Inc. drawings, specifications and test standards.

904 OXYGEN CLEAN PRODUCTS
Components and/or assemblies have OXYGEN BREATHING APPLICATION. Product shall be oxygen cleaned in accordance with drawing or specification requirements. Each shipment shall be accompanied by a signed certification or statement on the Certificate of Conformance that parts were cleaned in accordance with specification standards. All parts shall be packaged to maintain oxygen cleanliness and packaging shall be labeled to identify the parts as oxygen clean.

1000 CERTIFIED MATERIALS - Deleted

1100 DEFENSE RATED ORDER - Deleted